

Work Order ID 83800

83800

Page 1

April-26-12 11:41:12 AM

Item ID: D350-636-012

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Item Name: Skidtube RH

Stop *NS2*

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/26 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D2750

F

D3492

C

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy blue file and type labels per PPP D350-636-012 CHG 006

OK Rev MLJ 12/6/26
E 5/26/10

B 83800

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 83800***83800***

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Item ID: D350-636-012

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N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

110

0.00

110

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1- Pick D2600-3 Bent ✓

2- Deburr FWD and AFT ends, remove bending marks. Scribe batch# inside
AFT end per dwg D2750 ✓3- Drill pilot holes for blade fitting bolt holes using DT8983. Open to 0.500",
deburr. ✓4- Locate DT8329 off of blade fitting bolt holes and drill pilot holes for blade
fitting ✓

5- Drill only two fwd step holes using DT9616. Ensure proper positioning. ✓

6- Drill pilot holes as per Dwg D2750 sheet 4 (D2750-2 details). Drill using drill
Jig DT8150 & DT8863A for first side only DT8863B for second side (detail K) ✓7- Clecko DT8863B on second side of tube and drill pilot holes for detail B.
SECOND SIDE ✓8- Open up holes for Detail "K" to 0.375" (4 holes per side) and blade fitting
location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open up
holes for ground handling and detail L to 0.500" (8 holes per side) ✓9- Drill pilot holes for wearplates as per Dwg D2750 using DT8108 open to
0.297". ✓

10- Open up holes of Detail A to 0.297" (total of 2 holes per side) ✓

12-04-30

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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N900040100

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Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

11-Weld D2744 Cap as per Dwg D2750 and QSI 004. Fill grooves in bend left
from bending as per QSI 004
A/R Aluminum Rod batch: *M120854* *12/05/01*

12-Grind welds flush as per Dwg D2750

-> GF 12-5-1

120

QC10- Inspect visual per QSI004- ground welds

0.00

120

QC

Memo

0.00

Side slot

Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Side slot

Quality Control

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Approvals:

Process Plan:

Date:

Tooling:

Date:

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QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

NG 12-5-2

150

QC7-Inspect Chemical Conversion Coat

0.00

150

QC

Memo

0.00

Quality Control

DD 12-5-3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Required Date: 10/05/2012 Req'd Qty: 1.00

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Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start *NR1*

QC: Date:

SPC (Y/N): Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160		0.00							
160	Skidtubes								
Skidtubes	Memo	0.00							
Skidtubes	1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.								
	2-Open up holes of Detail K to 0.750" (total of 4 holes per side) as per dwg D2750.								
	3-Open float holes to .500" (4 per Side)								
	4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)								
	5-Deburr and blow out all chips from inside of tube								
	6-Prepare tube for welding, remove alodine as required.								
	7-Bond web D2739 in place as per QSI 015 A/R Sikaflex-291 batch: 21221 exp. date: 13/01/04								
	8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004 (welding instructions on sheet 9) A/R Aluminum Rod batch: M120854								
	9- At section AP-AP drill out x-bolt spacer to 0.404"								
	10-Grind welds flush as per Dwg D2750								
	11-Spot face ground handling holes section (total of 4 places per side) as per								

DC 12/05/03

- DC 12/05/04

> BE 12/05/07

> CC 12-5-9

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Skidtube RH

Start Date: 26/04/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

dwg D2750

12-Deburr holes

— *OK CC 12-5-9*

170

QC10- Inspect visual per QSI004- ground welds

0.00

170

QC

Memo

0.00

Quality Control

180

QC5- Inspect part completeness to step on W/O

0.00

180

QC

Memo

0.00

Quality Control

8/2/05/10

5/2/05/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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N9000040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool # Plan
Code Accept Qty Reject Qty Reject Number Insp. Stamp

190

Pressure Wash per QSI005 4.3

0.00

190

HandFinish

Memo

0.00

Hand Finishing

Re-alodine tube as per QSI 005 section 4.1.2.1 do not acid etch.

12-5-10

200

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

200

Powdercoat

Memo

0.00

Powder Coating

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

3-45 320°F 4-15

IX 12/05/10

210

QC3- Inspect Part Finish

0.00

210

QC

Memo

0.00

Quality Control

Inspect for foreign object per QSI 024

1 12-5-10

M121134

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Work Order ID 83800***83800***

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April-26-12 11:41:12 AM

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N9000040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00

230

HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts as per dwg D2750

2-Inspect for Foreign Objects

3-Spray inside of tube with "LPS-3"

batch: N/A

4-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: 121469EXP DATE: 13/6/7

5-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: 110348

6-Coat all exposed fasteners with "LPS Procyon"

batch: 1145961. 

W/O: 43800		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: D350-636-012 PAR #: _____ Fault Category: Skid tube NCR: Yes No DQA: Not Date: 12/07/19
 Resolution: _____ Disposition: Rework QA: N/C Closed Date: 12/3/20

NCR: 12-1584		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/6/13	# 230	Found Damin Assembly that D3488-041/42 Do not align with the skid tube hole. R.C. tol on D3488 + Process on skid (Hummer Drilling)	GP 12.06.04	Drill All 4 holes aft hole to max tol. on skid Drill All 5 holes on D3488 to max tol.	GP 12-6-6	S 12/6/13	GP 12.06.04	S 12/6/13
		XXXX	GP 12.06.04	Re Align as per as2005 + Re assembly. Per Day.	GP 12/6/20 (X1)	S 12/6/20	GP 12.06.04	S 12/6/13

NOTE: Date & initial all entries

Work Order ID 83800

April-26-12 11:41:12 AM

83800

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Item ID: D350-636-012

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Skidtube RH

Start Date: 26/04/2012 Start Qty: 1.00

1

Cust Item ID:

Required Date: 10/05/2012 Req'd Qty: 1.00

1

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00

240

QC

Memo

0.00

Quality Control

8/26/13

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

12/27/10

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

8/26/10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Work Order ID 83800

April-26-12 11:41:12 AM

83800

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N900040100Setup Start ***NS1***

Revision ID:

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Item Name: Skidtube RH

Start Date: 26/04/2012 Start Qty: 1.00

1

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Process Plan:

Date:

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Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

270

0.00

270

Packaging

Packaging

Memo

0.00

Packaging

Package as per PPP D350-636-012

280

0.00

280

QC21- Final Inspection - Work Order Release

QC

Memo

0.00

Quality Control

*R 12/7/10**R 12/7/11**R 120711*

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 83800

83800

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

Comments:

IPP Rev:102.09.25Rearranged procedure stepsKJ
 IPP Rev:J 06-03-29 As per Rev D EC
 IPP Rev:K 06-07.13 As per dsi9343 EC
 IPP Rev:L 07-07-28 Added SS Wearplates(Rev E) JLM Verified By:EC
 IPP Rev:M 08-04-22 update steps 4,13 DD verified by:EC
 IPP Rev:N 08-09-23 revF as per dwg DD verified by:ec IPP Rev:O
 10.06.22 revise seq110 DD verf:EC IPP Rev:P 10.10.01 as
 per IIN revH DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D2600-3-BENT

Manufactured No

110

Each

22.0000

1

1

D2600-3-BFNT

Extrusion Bent

**

①

MT

12-04-30

Location

Loc Qty

Loc Code

LG

22

66875

7

73253

1

75021

1

75022

1

75023

1

81330

4

82347

2

83305

5

D2744

Manufactured No

110

Each

24.0000

1

1

D2744

Cap

**

BE 12/05/01

Location

Loc Qty

Loc Code

LG002

24

62715

1

78900

23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item Name: Skidtube RH

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2739

Manufactured No

160

Each

6.0000

1

1

D2739

350 I Beam

**

DC 12/05/04

Location

B83448

Loc Qty

Loc Code

LG

6

72155

1

81508

1

83548

4

①

D2743

Manufactured No

160

Each

233.0000

8

8

D2743

Crossbolt Spacer

**

BE 12/05/07
B83262 x8

Location

Loc Qty

Loc Code

LG

-51

81965

159

LG001

284

67766

4

68251

3

73403

64

74445

1

79517

2

D3490-3

Manufactured No

160

Each

18.0000

4

4

D3490-3

Cross Bolt Spacer

**

BE 12/05/07
B83313 x4

Location

Loc Qty

Loc Code

LG

18

82016

18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Picklist Print

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Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3490-1

Manufactured No

160

Each

40.0000

4

4

D3490-1

Cross Bolt Spacer

**

BE 12/05/07
B 83269 x4

Location

Loc Qty

Loc Code

LG

31

81976

31

LG001

9

62450

2

74875

4

77042

3

D3631-1

Manufactured No

230

Each

507.0000

8

8

D3631-1

Washer

**

8

(2P)

12/05/14

Location

Loc Qty

Loc Code

FG

492

81874

92

83588 ✓

400

ST072

15

68062

2

75548

13

D3791-1

Manufactured No

230

Each

10.0000

1

1

D3791-1

Wearplate

**

1

(2P)

12/05/14

Location

Loc Qty

Loc Code

FP002

10

62239

2

82168

8

83392 ✓

April-26-12 11:41:16 AM

Shop Packet Print

Page 3

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 4

Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3793-3

Manufactured No

230 Each

16.0000 1 1

**

D3793-3

Wearshoe

Location

Loc Qty

Loc Code

FP001

16

80434

5

82166 ✓

11

MS21043-6

Purchased No

230 Each

702.0000 4 4

**

MS21043-6

NUT

Location

Loc Qty

Loc Code

FG

20

103693

20

ST301

682

117887 ✓

6

118384 ✓

176

120308

500

D3794-1

Manufactured No

230 Each

24.0000 1 1

**

D3794-1

Gasket

Location

Loc Qty

Loc Code

FP

23

82167 ✓

23

FP002

1

75042

1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

83800

D350-636-012

Page 5

14

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-010

Purchased

No

230

Each

227.0000

8

8

NAS1611-010

O-RING

**

8

SP

12/05/14

Location

Loc Qty

Loc Code

FP001

121581 ✓

227

110915

14

117460

8

118077

1

118612

3

119438

47

121166

8

121259

46

121415

100

D2741

Manufactured

No

250

Each

39.0000

1

1

D2741

Blade, 350 Skidtube

**

83135

L

Location

Loc Qty

Loc Code

ST

-10

ST466

49

71856

1

79516

38

NAS1515H3L

Purchased

No

230

Each

124.0000

4

4

*NAS1515H3I *

WASHER

**

4

SP

12/05/14

Location

Loc Qty

Loc Code

FG

121556 ✓

40

102472

40

ST277

84

118686

3

119438

1

120360

30

121243

50

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1611-013

Purchased

No

230

Each

142.0000

8

8

NAS1611-013

O-RING

**

1

(2P)

12/05/14

Location

Loc Qty

Loc Code

FP001

121584 ✓

142

116582

5

117291

2

117887

53

119623

36

121259

46

AN3C6A

Purchased

No

230

Each

415.0000

4

4

AN3C6A

BOLT

**

4

(2P)

12/05/14

Location

Loc Qty

Loc Code

FP001

~~121584~~ ✓

1

111982

1

ST351

414

111982

2

116419

23

116549

2

116704

12

117619

10

117688

1

117872

5

118422

13

119449

21

120423

3

120693 ✓

322

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

NAS1149C0832R

Purchased

No

230

Each

278.0000

1

1

NAS1149C0832R

WASHER

**

(28) 12/06/28

Location

Loc Qty

Loc Code

ST297

278

114915 ✓

278

D3536-25

Manufactured

No

230

Each

6.0000

1

1

D3536-25

Gasket

**

(28) 12/05/14

Location

Loc Qty

Loc Code

FP

6

83391 ✓

6

81342

6

D3794-3

Manufactured

No

230

Each

9.0000

1

1

D3794-3

Gasket

**

(28) 12/05/14

Location

Loc Qty

Loc Code

FP002

9

74530

2

80436

7

93396 ✓

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 8

Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN3C5A

Purchased

No

230

Each

1,510.000

34

34

AN3C5A

Bolt

**

34

20

12/05/14

Location

Loc Qty

Loc Code

FP001

7

115835

7

ST350

1503

116419

28

117343

13

117764

7

117872

2

119749

23

120423

62

1210168

-2

121068

370

121255

500

121444 ✓

500

D3537-1

Manufactured

No

230

Each

61.0000

3

3

D3537-1

Wearpad

**

3

20

12/05/14

Location

Loc Qty

Loc Code

FG

10

79833

10

FP002

51

69817

5

73716

2

83254

1

83255

43

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83800

83800

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3535-25

Manufactured No

230 Each

23.0000 1 1

D3535-25

Wearshoe

**

1

(2P)

14/05/14

Location

Loc Qty

Loc Code

FP001

23

62233

1

81357

5

82156 ✓

17

D3492-3

Manufactured No

230 Each

177.0000 8 8

D3492-3

Plug

**

8

(2P)

12/05/14

Location

Loc Qty

Loc Code

FP-A

177

81967

5

83099 ✓

172

AN960C10L

✗

NAS1149C0332

✓ Purchased

No

230 Each

0.0000 38 38

*AN960C10I *

washer

121569 ✓

**

38

(2P)

12/05/14

D3488-042

Manufactured No

230 Each

7.0000 1 1

D3488-042

Blade Fitting Assembly, RH

**

11

12/06/20

Location

Loc Qty

Loc Code

FP002

7

62003

1

75068

5

77015

1

B83417

xl

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Page 10

14

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-225

Purchased

No

230

Each

1,811.000

38

38

AI S4-1032-225

Insert

**

38

28

12/05/14

Location

Loc Qty

Loc Code

ST281

1788

108696

146

110768

62

118386

55

118966

68

121269 ✓

1457

ST282

23

120410

10

120451

13

D3492-1

Manufactured

No

230

Each

209.0000

8

8

D3492-1

Plug

**

8

28

12/05/14

Location

Loc Qty

Loc Code

FP002

14

69531

8

74444

2

76235

4

FP-A

195

81963

7

83098 ✓

188

D3793-1

Manufactured

No

230

Each

12.0000

1

1

D3793-1

Wearshoe

**

1

28

12/05/14

Location

Loc Qty

Loc Code

FP001

12

82171

12

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Shop Packet Print

Page 10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 11

Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

AN8C35A

Purchased

No

230

Each

89.0000

1

1

AN8C35A

BOLT

**

1

(2P)

12/06/28

Location

Loc Qty

Loc Code

FP002

88

115960

1

118286 ✓

37

121275

50

ST346

1

114442

0

115188

0

115960

1

MS21083C8

Purchased

No

230

Each

129.0000

1

1

MS21083C8

NUT

**

1

(2P)

12/06/28

Location

Loc Qty

Loc Code

304

99

121185 ✓

49

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

25

121524

25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Page 12

Work Order ID: 83800

83800

Parent Item: D350-636-012

D350-636-012

Parent Item Name: Skidtube RH

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D2745

Manufactured No

230 Each

290.0000 8 8

D2745

Bushing

**

8

12/05/14

Location

Loc Qty

Loc Code

FP	6	
79518	6	
FP001	284	
69529	1	
76142	1	
81964	120	
83260 ✓	162	

AN6C44A

Purchased No

230 Each

164.0000 4 4

AN6C44A

BOLT

**

4

12/05/14

Location

Loc Qty

Loc Code

FG	2	
103964	2	
ST343	162	
120143	4	
121013	11	
121167 ✓	97	
121440	50	

D3532-1

Manufactured No

250 Each

25.0000 2 2

D3532-1

Spacer

**

148204/
1483319

Location

Loc Qty

Loc Code

ST053	25	
78839	1	
82041	24	

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Page 13

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

MS21083C8

Purchased

No

250

Each

129.0000

2

2

MS21083C8

NUT

**

M 121349

Location

Loc Qty

Loc Code

304

99

121185

49

121349

50

FP002

1

115884

1

ST303

4

115884

0

118077

1

119309

2

119638

1

ST304

25

121524

25

NAS1149D0863J

Purchased

No

250

Each

175.0000

2

2

NAS1149D0863.I

WASHER

**

Location

Loc Qty

Loc Code

ST298

175

118078

34

119307

41

120308

100

M 120308

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

April-26-12 11:41:17 AM

Work Order ID: 83800

Parent Item: D350-636-012

Parent Item Name: Skidtube RH

Page 14

83800

D350-636-012

Start Date: 26/04/2012

Required Date: 10/05/2012

Start Qty: 1.00

Required Qty: 1.00

D3493-1

Manufactured No

250

Each

51.0000

2

2

D3493-1

Washer

**

Location

Loc Qty

Loc Code

ST050

51

70697

2

77573

1

78835

7

82023

41

83097

AN8C21A

Purchased

No

250

Each

85.0000

2

2

AN8C21A

BOLT

**

Location

Loc Qty

Loc Code

ST343

85

118758

3

121067

12

121167

20

121275

50

m121275

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

QTY -041	QTY -042	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
X				D2750-041	350 SKIDTUBE ASSEMBLY LH
	X			D2750-042	350 SKIDTUBE ASSEMBLY RH
		X		D2750-043	350 SKIDTUBE ASSEMBLY LH
			X	D2750-044	350 SKIDTUBE ASSEMBLY RH
1	1	1	1	D2739	WEB
8	8	8	8	D2743	SPACER
1	1	1	1	D2744	CAP
8	8	8	8	D2745	BUSHING
1				D2750-1	SKIDTUBE WELDMENT LH
	1			D2750-2	SKIDTUBE WELDMENT RH
		1		D2750-3	SKIDTUBE WELDMENT LH
			1	D2750-4	SKIDTUBE WELDMENT RH
1		1		D3488-041	BLADE FITTING LH
	1		1	D3488-042	BLADE FITTING RH
4	4	4	4	D3490-1	SPACER
4	4			D3490-3	SPACER
		4	4	D3490-5	SPACER
8	8	8	8	D3492-041	PLUG ASSEMBLY
8	8			D3492-043	PLUG ASSEMBLY
		8	8	D3492-045	PLUG ASSEMBLY
1	1	1	1	D3535-25	WEARSHOE
1	1	1	1	D3536-25	GASKET
3	3	3	3	D3537-1	WEARPAD
8	8	8	8	D3631-1	WASHER
1	1	1	1	D3791-1	WEARPLATE
1	1	1	1	D3793-1	WEARSHOE
1	1	1	1	D3793-3	WEARSHOE
1	1	1	1	D3794-1	GASKET
1	1	1	1	D3794-3	GASKET
38	38	38	38	ALS4-1032-225	INSERT (OR ALS7-1032-225 AKS4-1032-225, AELS-1032-225)
34	34	34	34	AN3C5A	BOLT
4	4	4	4	AN3C6A	BOLT
4	4	4	4	AN6C44A	BOLT
1	1	1	1	AN8C35A	BOLT
38	38	38	38	AN960C10L	WASHER
1	1	1	1	AN960C816L	WASHER
4	4	4	4	MS21043-6	NUT
1	1	1	1	MS21083C8	NUT
4	4	4	4	NAS1515H3L	WASHER

GENERAL NOTES:

- 1) MATERIAL: MAKE D2750-1/-2/-3/-4 FROM D2600-3 EXTRUSION (INITIAL LENGTH = 120.0).
- 2) FINISH:
ACID ETCH, ALONDE ASSEMBLY PER DART QSI 005 4.1 PRIOR TO INSTALLING D2739 WEB.
POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT AS INDICATED TO 1.0 ABOVE SKIDTUBE CENTER-LINE PER DART 005 4.4 (OPTIONAL).
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D2750-041/-042/-043/-044 = 26.5 LBS
- 8) WELD PER DART QSI 004
- 9) INSTALL ALS4-1032-225 INSERTS AFTER FINISH AS INDICATED. DRILL 'F' SIZE HOLES ($\phi 0.297$) FOR WEARSHOE INSERTS
- 10) FINAL CONFIGURATION SHOULD HAVE THE FOLLOWING MINIMUM MECHANICAL PROPERTIES:
MINIMUM YIELD TENSILE STRENGTH = 35 KSI
MINIMUM ULTIMATE TENSILE STRENGTH = 38 KSI
- 11) SPRAY INSIDE OF TUBE WITH A COAT OF LPS LABORATORIES "LPS-3" AFTER FINISH AND AFTER INSTALLATION OF INSERTS.
COAT ALL EXPOSED FASTENERS WITH LPS LABORATORIES "LPS PROCYON" AFTER FINAL ASSEMBLY. CLEAN EXCESS OFF
POWDER COATING WITH MEK DEGREASER.
- 12) SPACER AND PLUG INSTALLED SAME AS SECTION AJ-AJ EXCEPT HORIZONTAL
- 13) SPACER AND PLUG INSTALLED SAME AS SECTION AP-AP EXCEPT HORIZONTAL

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. 83800 MLJ
12/04/26

RELEASED

F	INCORPORATE DSI 9413. QTY (3) D3537-1 WAS QTY (5) (ZN C8-1) D3791-1/-3 REPLACES D3535-13/-35 (ZN C8-1). D3794-1/-3 REPLACES D3536-13/-35 (ZN B8-1). ADD D3791-1 (ZN C8-1). WEARSHOE HOLES UNDER FWD/AFT SADDLE REMOVED (8 PL). WEARSHOE HARDWARE QTY UPDATED (ZN B8-1). D3488-041/-042 HARDWARE UPDATED (ZN C1-8, 9, 10, 11). ADD NOTE 12 AND 13 (ZN A6-1). REASON REF NCR 08-043	PH	08 07 16
E	CHANGE TO STAINLESS STEEL WEARPLATES. ADD RUBBER GASKETS. CHANGE INSERTS. ADD D3631-1. REMOVE QTY (38) NAS1515H3L. REMOVE QTY (10) NAS1515H8L. REMOVE D2741. QTY (2) AN960C816. REMOVE QTY (2) MS21083C8	CB	07 05 17
D	ADD HOLES AND SPACERS FOR APICAL FLOATS. INCORPORATE DEC 9139157	PH	06.01.05
C	ADD D2750-3/D2750-4. INCORPORATE D2738 AND D2740	CP	98.11.18
B	CHANGE MS24694-S293 TO AN8-16A	CP	98.09.01
A	NEW ISSUE	DS	98.04.16
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR			
DATE	08.07.16		

DART AEROSPACE USA, INC.
PORT HADLOCK, WA

DRAWING NO
D2750
REV. F
SHEET 1 OF 11
TITLE
350 SKIDTUBE ASSEMBLY
SCALE
NTS

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Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

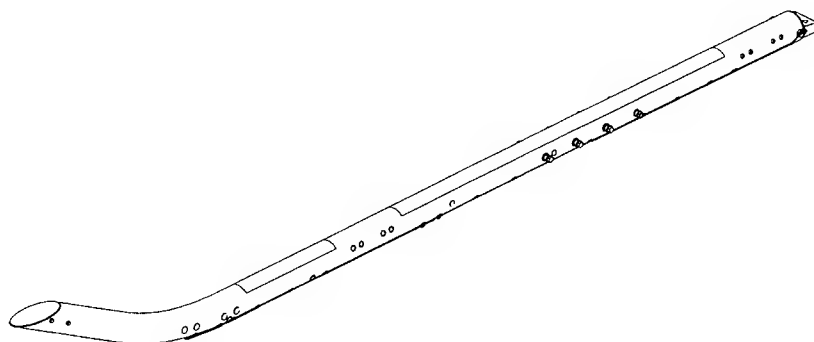
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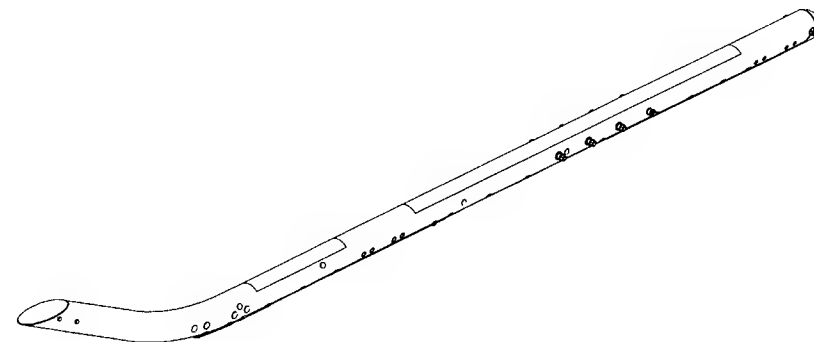
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

83800



D2750-041 350 SKIDTUBE ASSEMBLY, LH



D2750-042 350 SKIDTUBE ASSEMBLY, RH

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08-02-1988

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APPROVED	PCY	TITLE	SCALE
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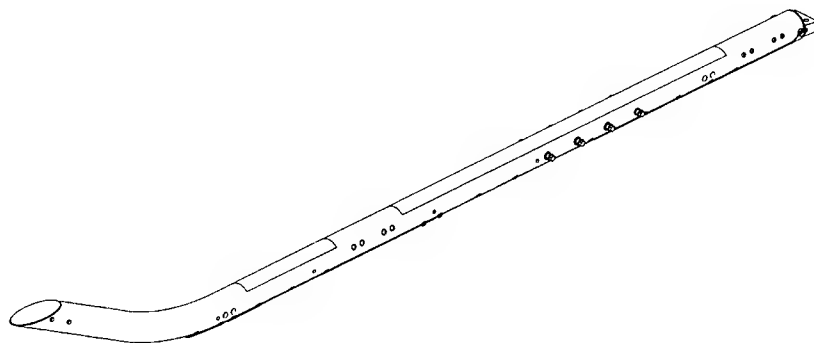
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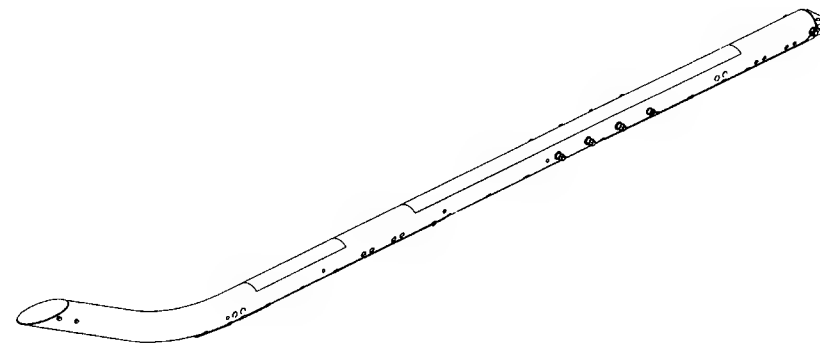
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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83800



D2750-043 350 SKIDTUBE ASSEMBLY, LH



D2750-044 350 SKIDTUBE ASSEMBLY, RH

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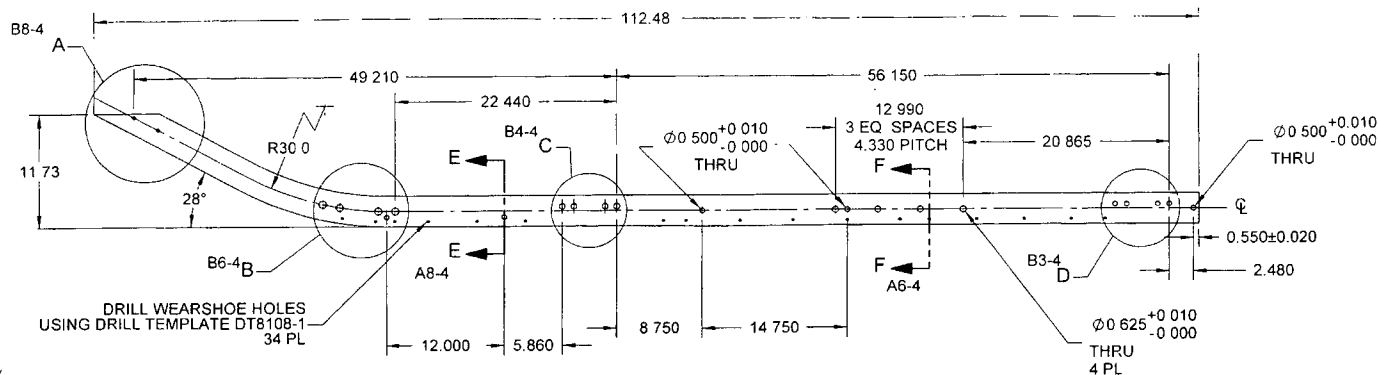
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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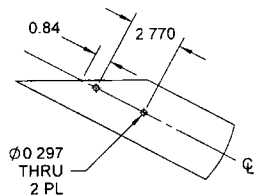
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

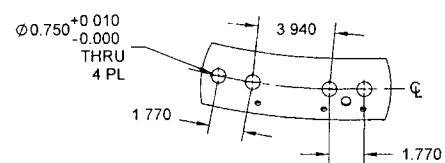
83800



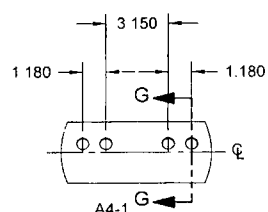
D2750-1 LH SKIDTUBE



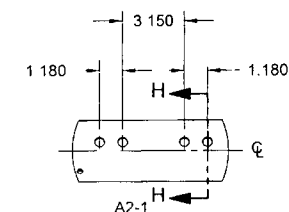
DETAIL A
SCALE 2X



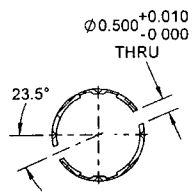
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SCALE 2X



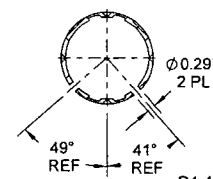
DETAIL C
SCALE 2X



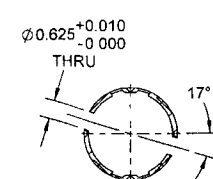
DETAIL D
SCALE 2X



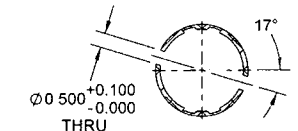
SECTION E-E
SCALE 3X, 2 PL



SECTION F-F
SCALE 3X, 17 PL



SECTION G-G
SCALE 3X, 4 PL



SECTION H-H
SCALE 3X, 4 PL

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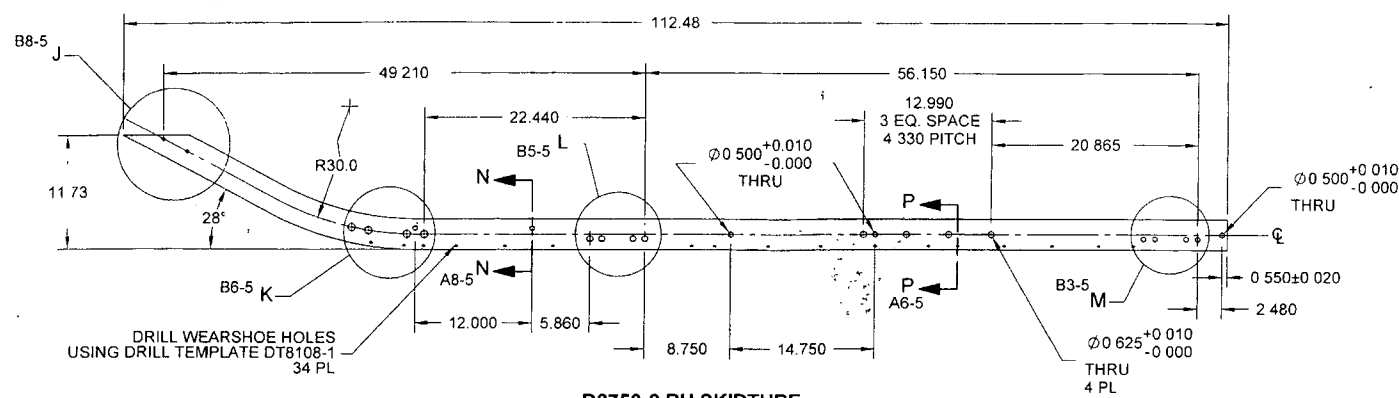
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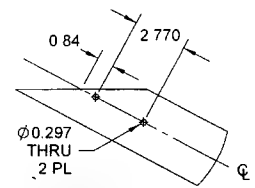
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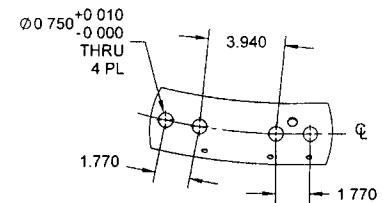
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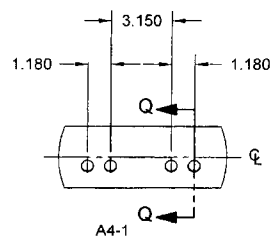
D2750-2 RH SKIDTUBE



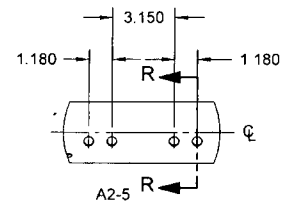
DETAIL J
SCALE 2X



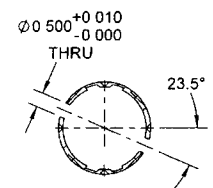
DETAIL K
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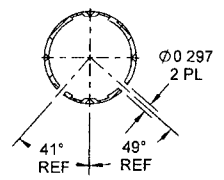
DETAIL L
SCALE 2X



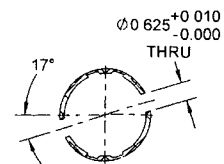
DETAIL M
SCALE 2X



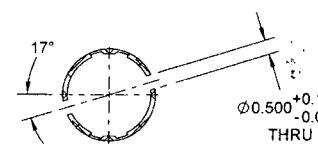
SECTION N-N
SCALE 3X, 2 PL



SECTION P-P
SCALE 3X, 17 PL



SECTION Q-Q
SCALE 3X, 4 PL



SECTION R-R
SCALE 3X, 4 PL

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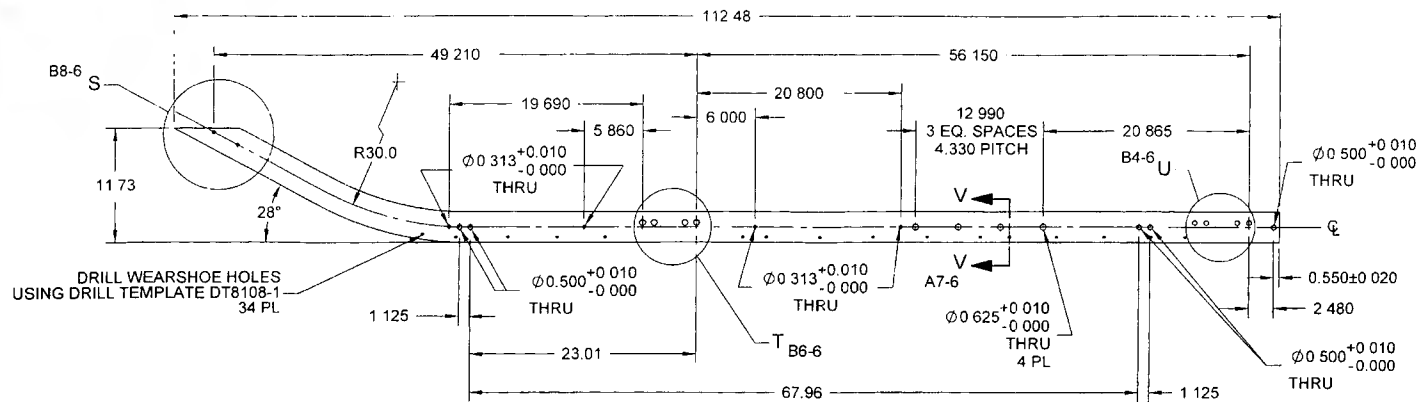
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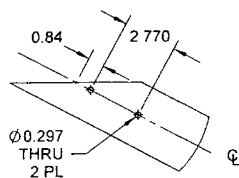
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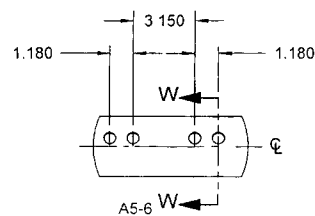
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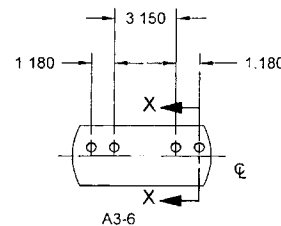
D2750-3 LH SKIDTUBE



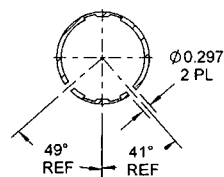
DETAIL S
SCALE 2X



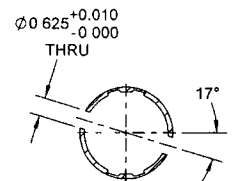
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SCALE 2X



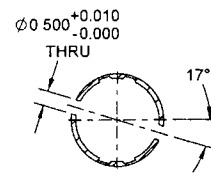
DETAIL U
SCALE 2X



SECTION V-V
SCALE 3X, 17 PL



SECTION W-W
SCALE 3X, 4 PL



SECTION X-X
SCALE 3X, 4 PL

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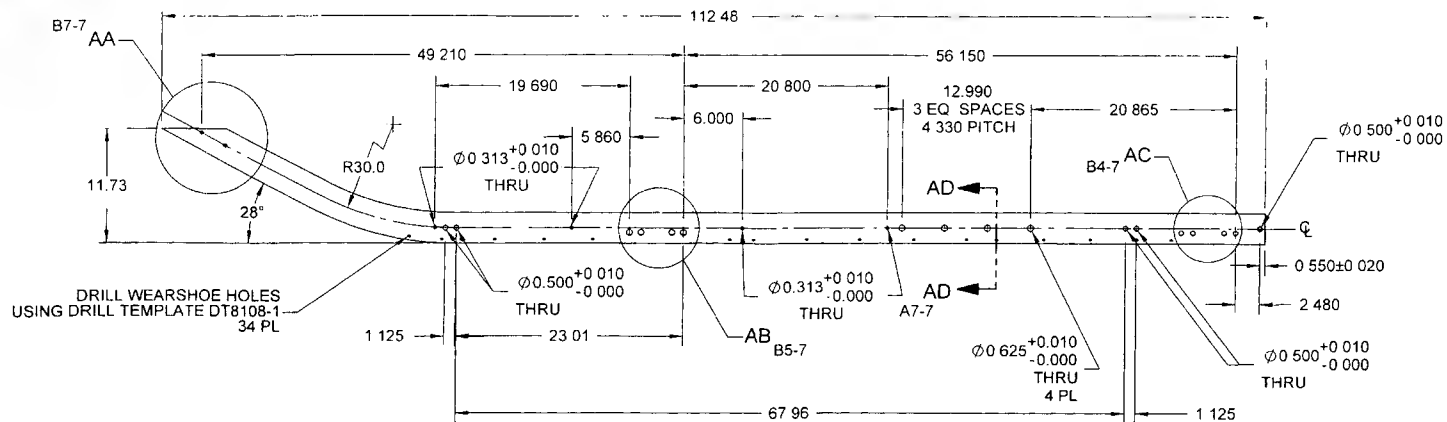
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

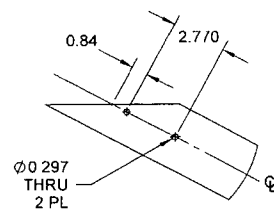
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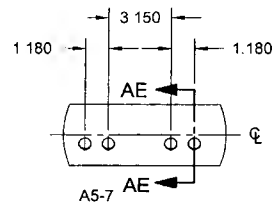
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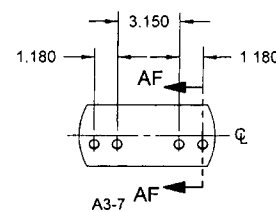
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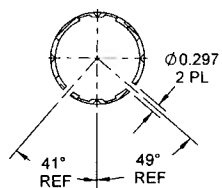
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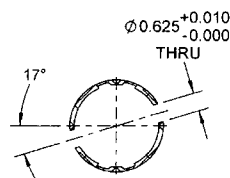
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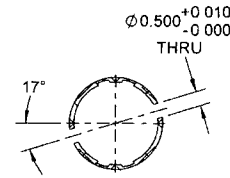
DETAIL AC
SCALE 2X



SECTION AD-AD
SCALE 3X, 17 PL



SECTION AE-AE
SCALE 3X, 4 PL



SECTION AF-AF
SCALE 3X, 4 PL

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08-02-1978

DESIGN	PA	DART AEROSPACE USA, INC.	
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

8 7 6 5 4 3 2 1

83800

AN6C44A BOLT
D2745 BUSHING
D3631-1 WASHER
SKIDTUBE, REF
D3631-1 WASHER
D2745 BUSHING
MS21043-6 NUT
4 PL
(INSTALL BOLT ON THIS SIDE)

BOND D2739 WEB INTO D2750-1 OUTER TUBE
WITH NON-STRUCTURAL SIKAFLEX-241 ADHESIVE
PER DART QSI 015
NOTE ENSURE THAT HOLES LINE UP

BLACK ANTI-SKID

A1-8 AG

D2750-1 SKIDTUBE

AFTER FINISH
ALS4-1032-225 INSERT
34 PL

AH

AJ

REFER TO SECTION AJ-AJ

A7-8

AK

AK

B5-8

2.0 TYP

1.78 TO D2739 WEB

D3488-041 BLADE FITTING

AN8C35A BOLT
D3793-3 WEARSHOE REF
D3794-3 GASKET, REF
SKIDTUBE, REF
D3488-041 BLADE FITTING, REF
SKIDTUBE, REF
D3794-3 GASKET, REF
D3793-3 WEARSHOE, REF
AN960C816L WASHER
MS21083C8 NUT
(INSTALL BOLT ON THIS SIDE)

D3794-1 GASKET

D3793-1 WEARSHOE

AN3C5A BOLT
AN960C10L WASHER
34 PL

D3537-1 WEARPAD

D3791-1 WEARPLATE

D3536-25 GASKET

D3535-25 WEARSHOE

D3794-3 GASKET

D3793-3 WEARSHOE

D3537-1 WEARPAD

D2750-041 350 SKIDTUBE ASSEMBLY, LH

AFTER FINISH, INSTALL D3492-043 PLUG ASSEMBLY BOTH ENDS

D3490-3 SPACER

TYP

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø 0.750 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

C7-8

SECTION AH-AH
SCALE 3X, 4 PL

D2743 SPACER

TYP

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484

C6-8

SECTION AK-AK
SCALE 3X, 4 PL

D2744 CAP

1/16" G

AFTER FINISH, INSTALL ALS4-1032-225 INSERT AN3C6A BOLT AN960C10L WASHER NAS1515H3L WASHER 4 PL

1/16" G

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D2743 SPACER (Ø 0.625 HOLES)
3) WELD INTO PLACE, GRIND FLUSH
4) DRILL OUT SPACER TO Ø 0.484
5) SPOT FACE Ø 0.750 (BOTH SIDES)

C4-8

SECTION AL-AL
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)

D3490-1 SPACER

AFTER FINISH, INSTALL D3492-041 PLUG ASSEMBLY BOTH ENDS

WELDING INSTRUCTIONS
1) CHAMFER HOLE 0.050 X 45°
2) INSERT D3490-1 SPACER (Ø 0.500 HOLES)
3) WELD INTO PLACE, GRIND FLUSH

C6-8, D5-8

SECTION AJ-AJ
SCALE 3X, 4 PL

DETAIL AG
SCALE 2X

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08.07.16

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SECTION AH-AH
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
SECTION AK-AK
SCALE 3X, 4 PL

SECTION AJ-AJ
SCALE 3X, 4 PL

SECTION AL-AL
SCALE 3X, 4 PL

DETAIL AG
SCALE 2X

RELEASE

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DRAWN		PORT HADLOCK, WA	
CHECKED		DRAWING NO	REV
MFG APPR		D2750	SHEET 8 OF
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NT
DATE	08.07.16	COPYRIGHT © 1998 BY DART AEROSPACE USA, INC. <small>THIS DOCUMENT IS PRIVATE AND UNCLASSIFIED. IT IS NOT TO BE REPRODUCED OR TRANSMITTED IN ANY FORM OR BY ANY MEANS, ELECTRONIC OR MECHANICAL, INCLUDING PHOTOCOPYING, RECORDING, OR BY ANY INFORMATION STORAGE AND RETRIEVAL SYSTEM, WITHOUT PERMISSION IN WRITING FROM DART AEROSPACE USA, INC.</small>	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

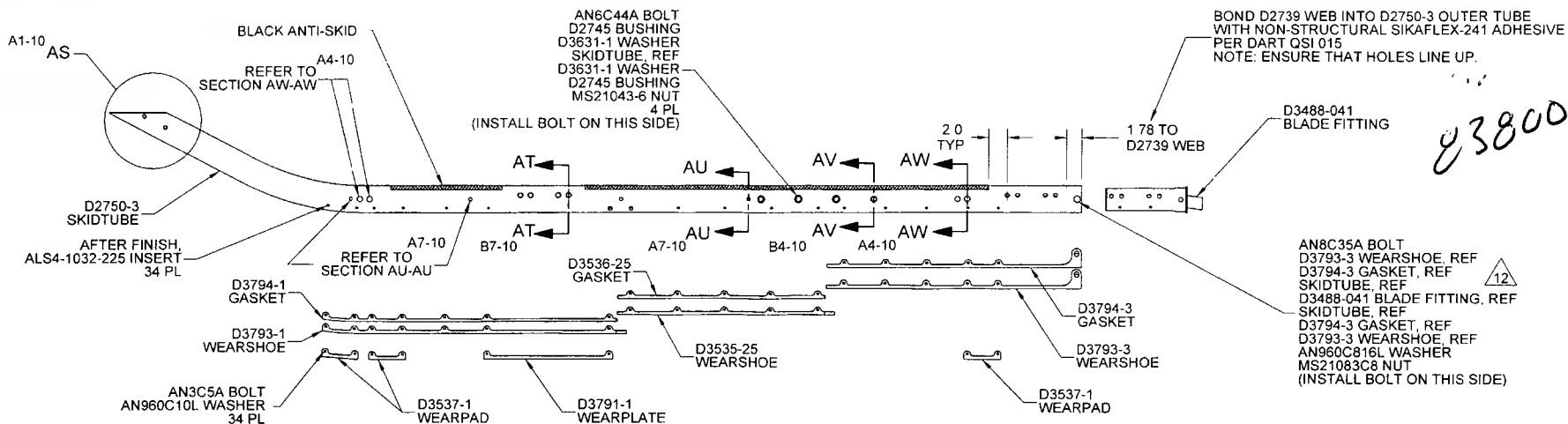
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

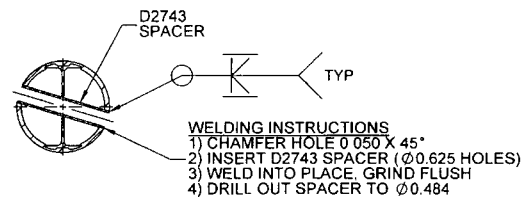
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NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

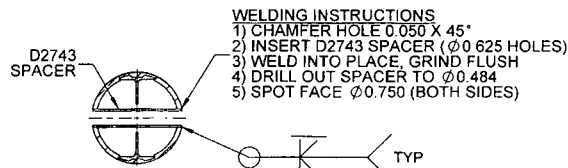
NOTE: Date & initial all entries



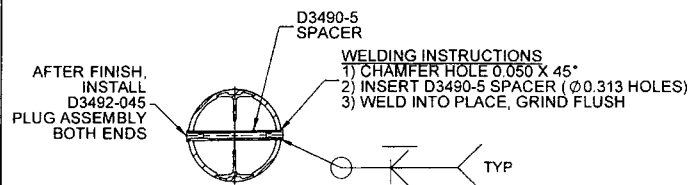
D2750-043 350 SKIDTUBE ASSEMBLY, LH



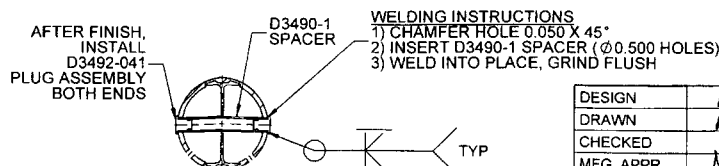
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SCALE 3X, 4 PL



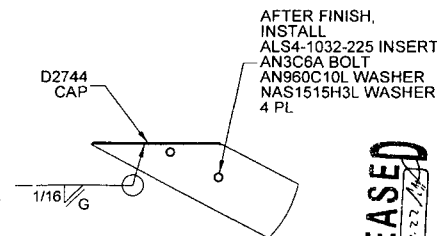
SECTION AV-AV
SCALE 3X, 4 PL
(HARDWARE REMOVED FOR CLARITY)



SECTION AU-AU
SCALE 3X, 4 PL



SECTION AW-AW
SCALE 3X, 4 PL



DETAIL AS
SCALE 2X

DESIGN		DART AEROSPACE USA, INC.	
DRAWN		PORT HADLOCK, WA	
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MFG APPR.		D2750	SHEET 10 OF 11
APPROVED		TITLE	SCALE
DE APPR.		350 SKIDTUBE ASSEMBLY	NTS
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27 JUL 2016

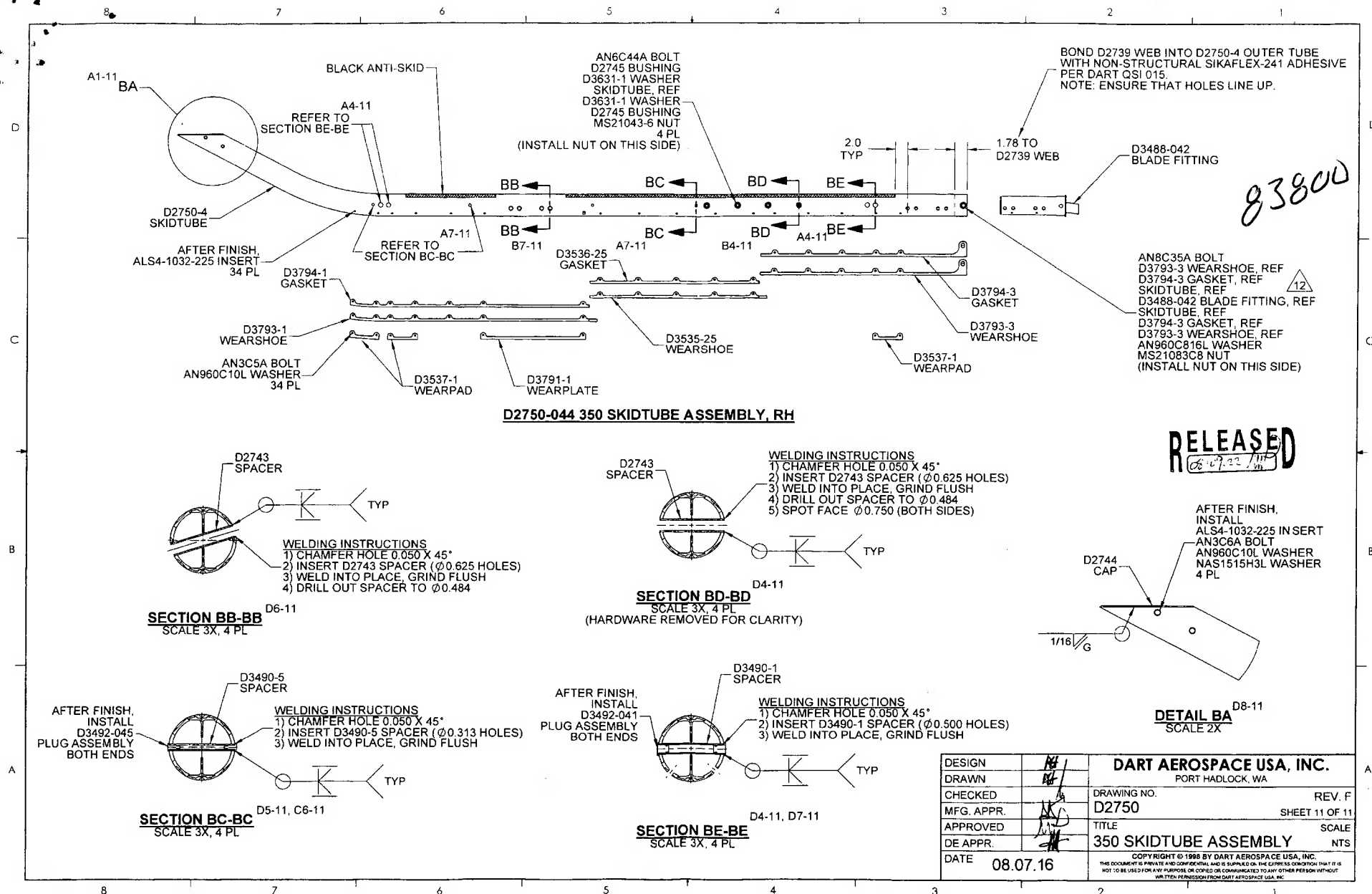
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & Initial all entries

NO. 294

AWS D17.1.2001
QUALIFICATION TEST RECORD

Name: Berday Elliott
Job number: 83800
Part number: A350-636-012
Description: Skid tube
Welding Process: Tig[☒] Mig[]
Base material: Alum
Current: AC[☒] DC[]

TEST REQUIREMENTS AND RESULTS

Visual: pass[☒] fail[]
Penetration: pass[☒] fail[]

UNACCEPTABLE

Cracks: pass[☒] fail[]
Undercut: pass[☒] fail[]
Pin holes: pass[☒] fail[]
Overlap (cold lap): pass[☒] fail[]
Porosity (surface): pass[☒] fail[]
Coloration: pass[☒] fail[]

Qualifier David Arual Date of Test Coupon 12.05.09
Welder Berday Elliott Date of Test Coupon 12.05.09

The above named individual is qualified in accordance with AWS D17.1.2001 to weld